

Date: Tuesday, 3/11/2008 7:57:39 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 37751	
Estimate Number : 10601	
P.O. Number :	Part Number : D25777
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 30469	Material :
Written By :	Due Date : 4/4/2008 Qty: 10 Um: Each
Checked & Approved By : <u>108 03 11</u>	
Comment : Est: 02.09.24 Re-format KJ	
Est Rev:G Now On Waterjet 07-01-26 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 1.0143 sf(s)/Unit Total : 10.1430 sf(s)

1010/1025/A21/6aA SHEET

Batch: 105706 IB 8-3-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2577

Dwg Rev: E

Prog Rev: E

IB 8-3-20

(11)

2-Deburr if necessary

IB 8-3-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 8-3-20 ALL

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

IB 8-3-20

Done at step 2.2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 37751

Part Number: D2577

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Identify as D2577-7

3-Form joggle as per Dwg D2577 using DT8157.

SR 08/04/03

08/04/03

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

BR 08-04-03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/04

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR-19

BR 08-04-04

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W 08-04-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

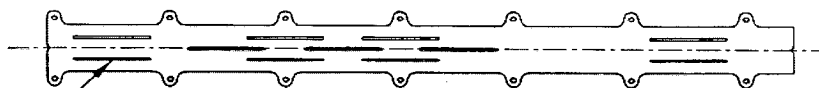
NOTE: Date & initial all entries



RELEASED
00.09.22

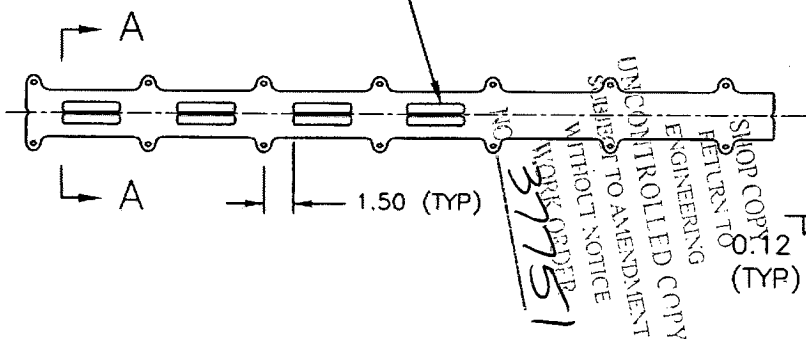
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

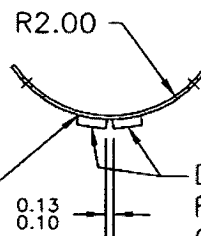


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5

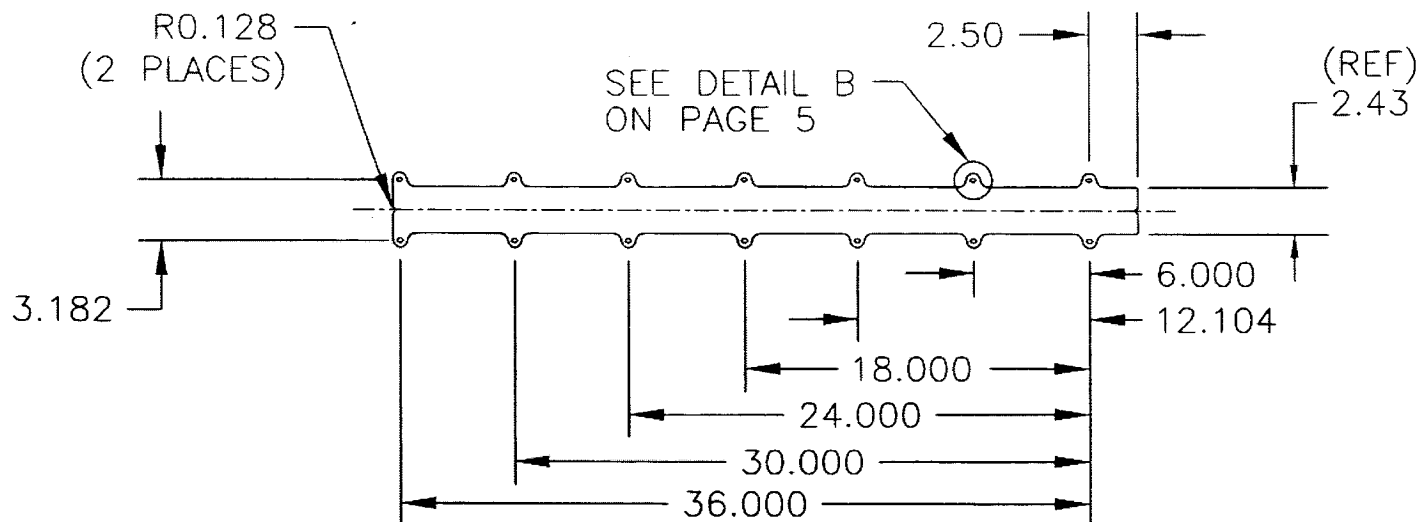


D2941-300 (REF)
REMOVE POWDER
COAT FROM THESE
SURFACES

D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2577	SHEET 2 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	



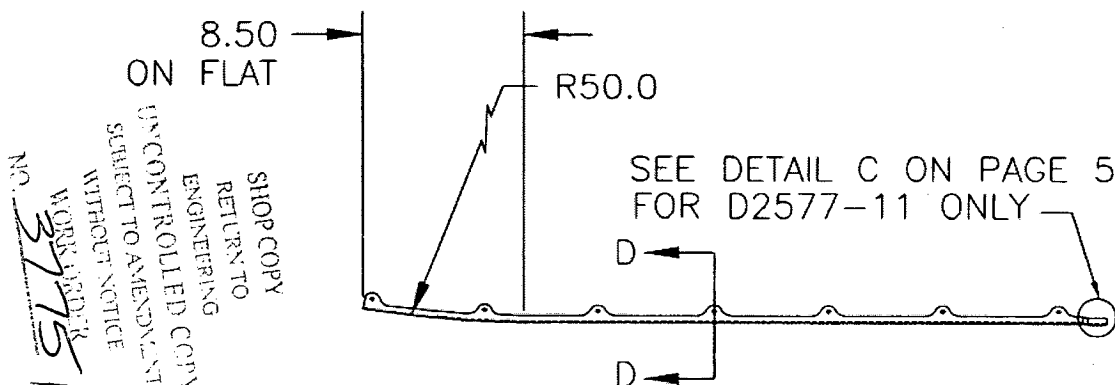
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

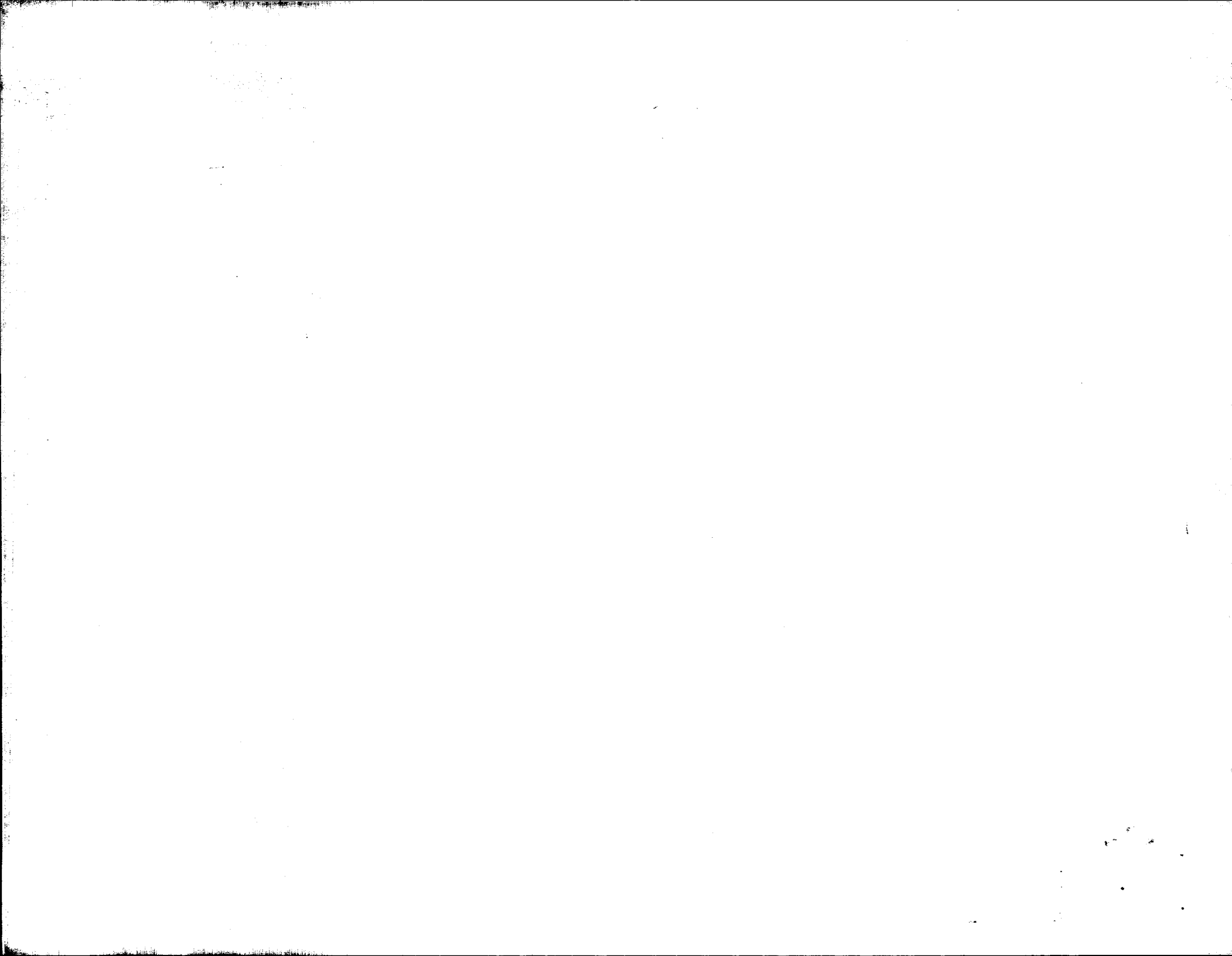


D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.26

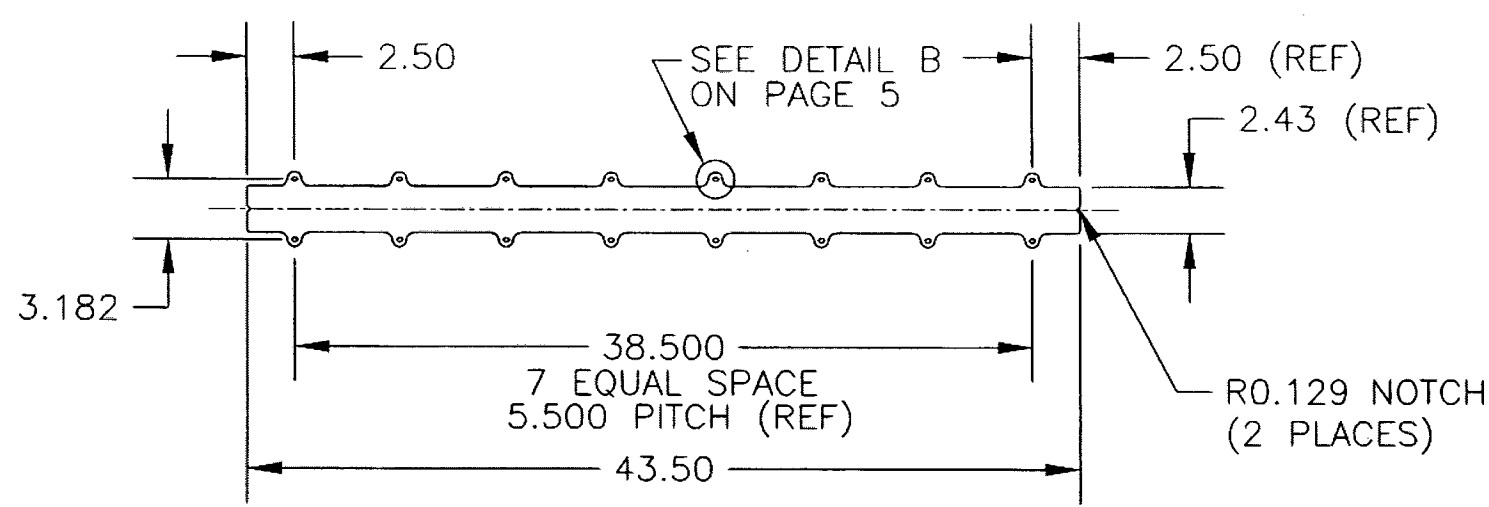


DART

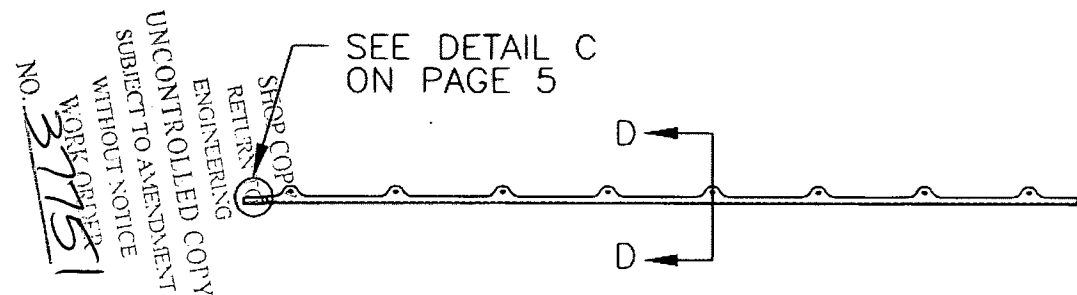


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DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 3 OF 5 SCALE 1:10

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 00.09.26

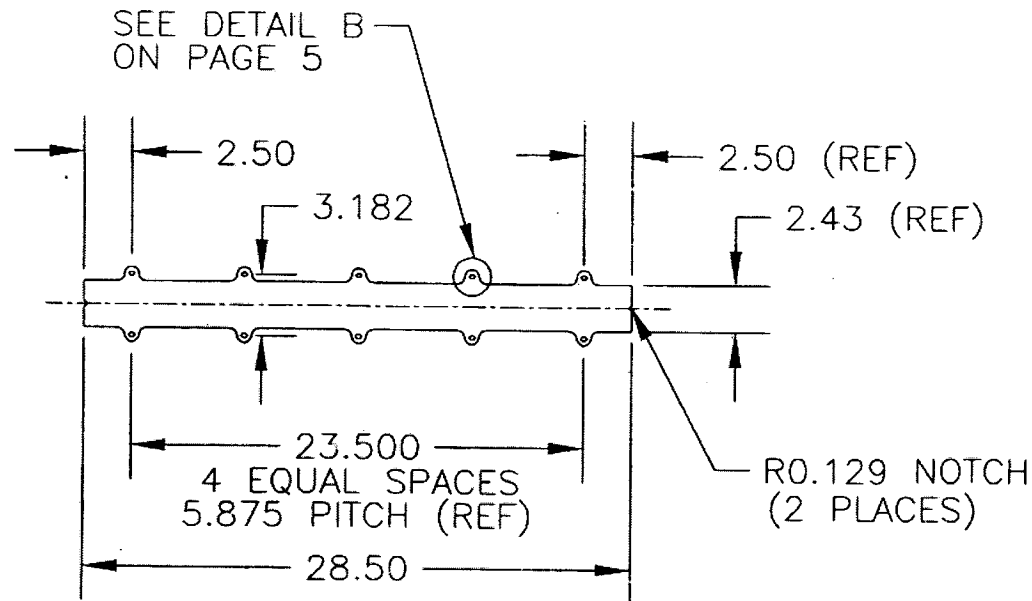
DART



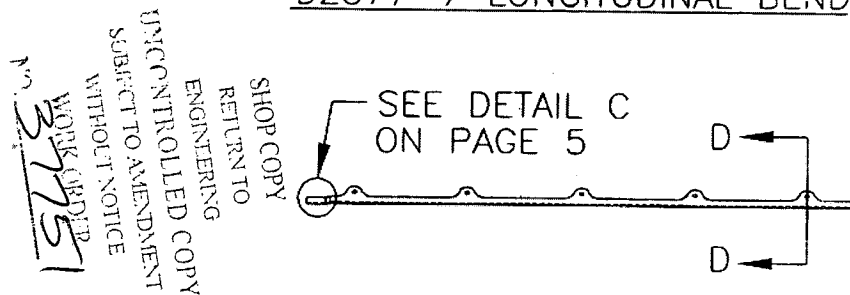
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CHECKED	APPROVED	DRAWING NO. D2577	SHEET 4 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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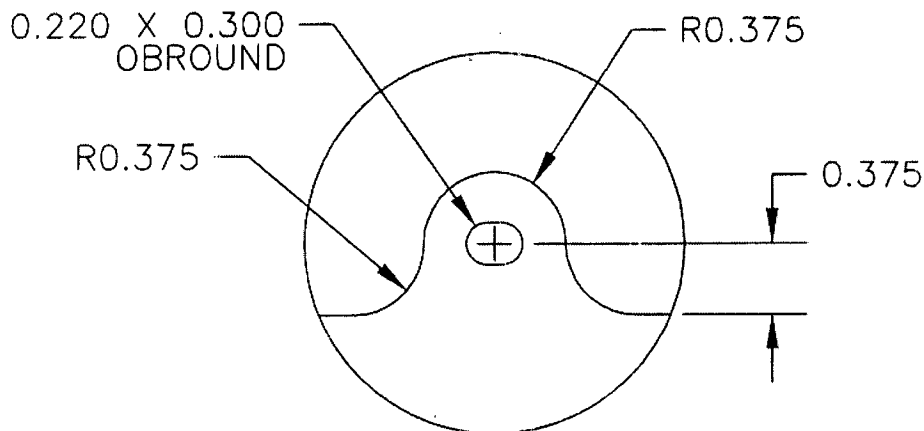
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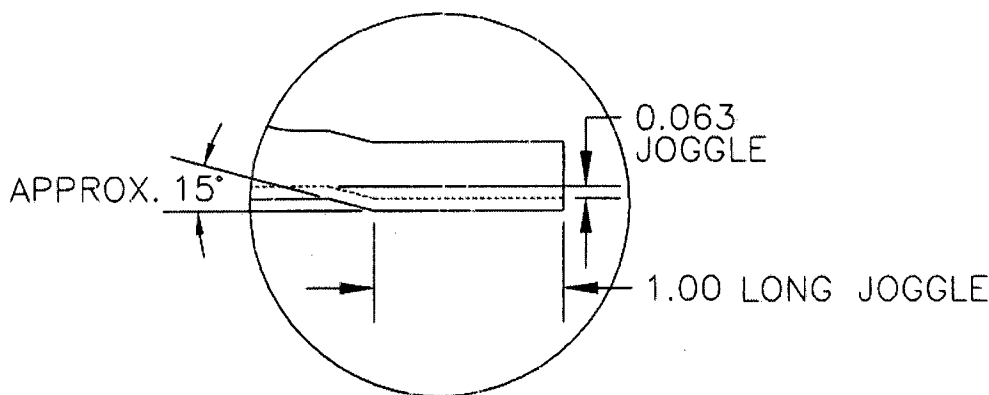
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

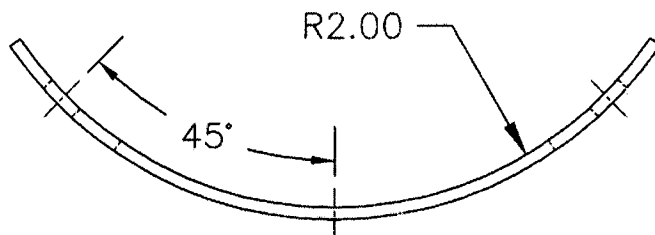
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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